DRAB GREEN

Work Order ID 65515

January 19, 2011 11:30:55 AM

Item ID: D2573 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle, Aft Out 205

Start Date: 1/20/11 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 2/11/11 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D2573	Rev E

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	HAAS CNC VERTICAL MACHINING #1	0.00				10			
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp SA 11/2/17 JL								
110	CONVENTIONAL MILLING MACHINE	0.00				10			
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine keyway as per dwg D2573 & D2574 SA 11/2/17 JL								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				10			
QC	**Memo**	0.00							
Quality Control	SA 11/2/17 JL								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65515

January 19, 2011 11:30:55 AM

Item ID: D2573 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle, Aft Out 205

Start Date: 1/20/11 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 2/11/11 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check	0.00				10	Ø		
	Memo	0.00							

mk 11/02/08

140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				10	DR 11-02-9.		
	Memo	0.00							

150 Powdercoat Powder Coating	~~White Gloss~~(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				(10X)	mk 11/03/01		
	Memo	0.00							

POWDER COAT DRAB GREEN
PER QSI 005
START TIME: 11:15 ☐OVEN TEMPERATURE: 320°F
☐FINISH TIME: ~~12:15~~

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65515

January 19, 2011 11:30:55 AM

Item ID: D2573 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Saddle, Aft Out 205

Start Date: 1/20/11 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 2/11/11 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				10	0		11/03/02
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location V23	0.00							11/3/02
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							11/03/02
QC	**Memo**	0.00							
Quality Control									CL 11/03/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 19, 2011 11:30:54 AM

Work Order ID: 65515

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 1/20/11 **Required Date:** 2/11/11

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007 Saddle Billet		Manufactured	No			100	Each	18.0000	1	10	SA	11/3/12	

Location	Loc Qty	Loc Code	
MAT42	18		
46412	2		2
62713	16		1

65383 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	65515
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443		.442	.438	.438	.438	Vern	11-3
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001	Vern	CNC-02
F	0.490	0.510		.501	.502	.505	.510		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.504	.503	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.570	.568	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.124	.125	mic	118-120
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250	[illegible]	
S	0.115	0.135		.128	.129	.130	.127	mic	118-120
T	0.178	0.198		.188	.188	.188	.188	R-G	
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.237	.238	.240	.237		
W	0.115	0.135		.127	.130	.129	.128	mic	118-120
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500	R-G	
AB	0.615	0.635		.627	.628	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.247	.247		
AE	1.500	1.520		1.516	1.514	1.514	1.515	dial	
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.248	.249	.248		
AI	2.000	2.020		2.005	2.004	2.004	2.005	dial	
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	11/01/31

Audited by	[signature]
Date:	11/02/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[signature]

DART AEROSPACE LTD	Work Order:	65515
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.507	.506	.507	.506		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.502	.502	.502	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.126	.125	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.128	.130	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.238	.239	.240	.239		
W	0.115	0.135		.129	.128	.129	.129		
X	0.308	0.313		.310	.310	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.248	.248	.249		
AE	1.500	1.520		1.514	1.514	1.514	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.248	.249	.248	.249		
AI	2.000	2.020		2.003	2.004	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	11/02/02

Audited by	ark
Date:	11/02/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	65515
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

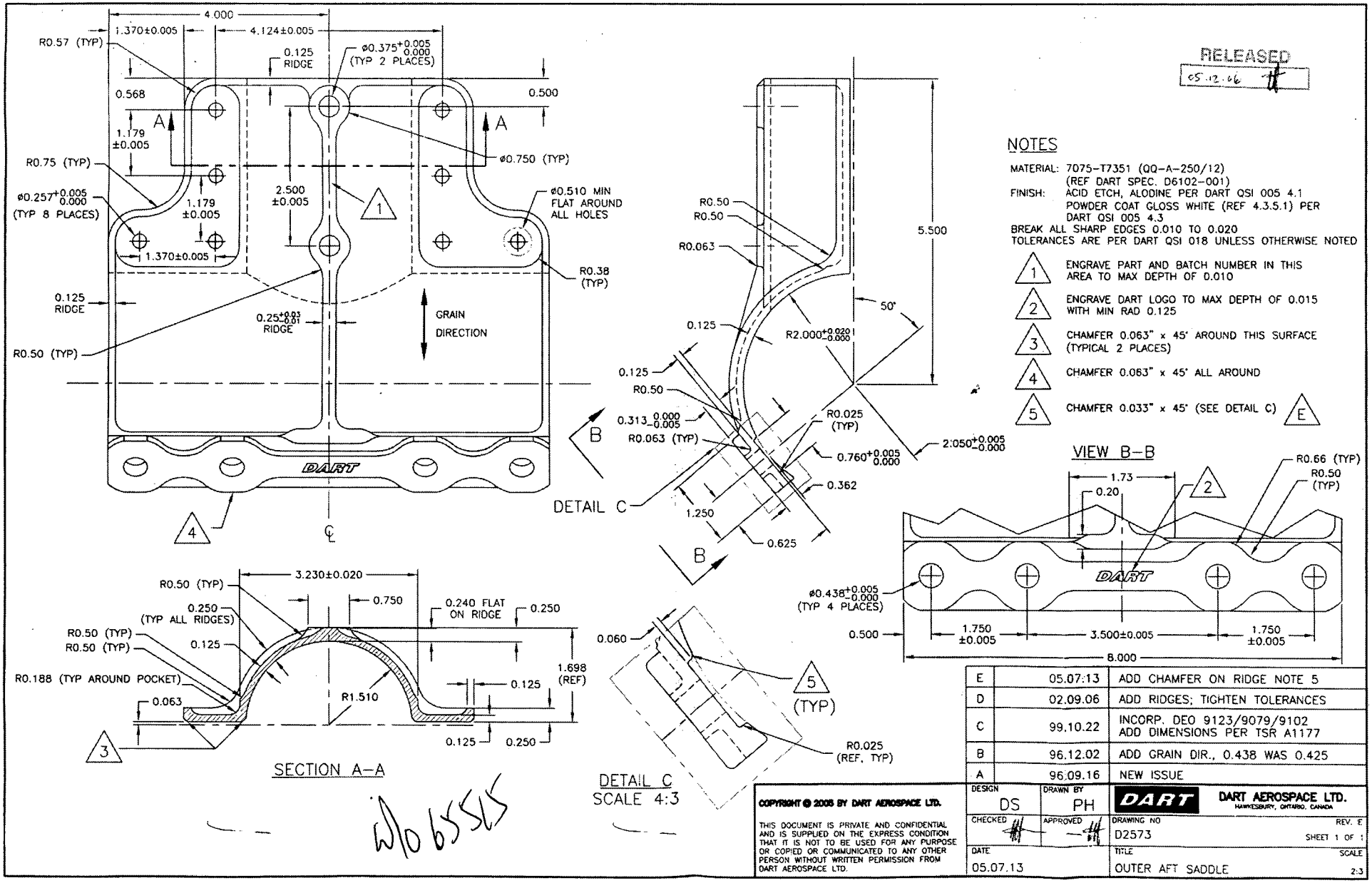
Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.001				
F	0.490	0.510		.503	.503				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.502	.502				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.568				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.127	.127				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.237	.238				
W	0.115	0.135		.125	.129				
X	0.308	0.313		.311	.314				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.363	.363				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627	.627				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.245	.246				
AE	1.500	1.520		1.515	1.515				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.247	.248				
AI	2.000	2.020		2.004	2.004				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	
Date:	11/2/08

Audited by	
Date:	11/02/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



RELEASED
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
3. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
4. CHAMFER 0.063" x 45° ALL AROUND
5. CHAMFER 0.033" x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO: D2573	REV. E
DATE: 05.07.13		TITLE: OUTER AFT SADDLE	SCALE: 2:3

SHEET 1 OF 1

W/O 65515